

CLAIMS

1. An oil for metal working comprising a triester of fatty acids and glycerin,

5 the oil for metal working being characterized in that the content of oleic acid in the fatty acids is 40-98 % by mass based on the total amount of the fatty acids.

2. The oil for metal working according to claim 1, characterized by further comprising a hydrocarbon oil, and in that the content of said triester is 1-50 % by mass based on the total amount of the composition.

10 3. The oil for metal working according to claim 1 or 2, characterized in that the content of linoleic acid in the fatty acids is 1-60 % by mass based on the total amount of the fatty acids.

15 4. The oil for metal working according to any one of claims 1 to 3, characterized in that the content of C1-C16 fatty acids in the fatty acids is 0.1-30 % by mass based on the total amount of the fatty acids.

5. The oil for metal working according to any one of claims 1 to 4, characterized in that the content of C6-C16 fatty acids in the fatty acids is 0.1-30 % by mass based on the total amount of the fatty acids.

20 6. The oil for metal working according to any one of claims 1 to 5, characterized by further comprising a monoester and/or a diester.

7. The An oil for metal working according to any one of claims 1 to 6, characterized by being used as a cutting oil, a grinding oil or a roll forming oil.

25 8. The oil for metal working according to any one of claims 1 to 7, characterized by being used as a metal working oil for heavy machining, a metal working oil for difficult machining or a metal

working oil for machining of difficult-to-cut materials and/or difficult-to-grind materials.

9. The oil for metal working according to any one of claims 1 to 8, characterized by being used as an oil for metal working with a minimal quantity lubricant system.

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